

SPLIT

139.7

Date: Friday, 02/05/2008 8:50:07 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BRACKET ASSEMBLY		
Job Number	38982				22		
Estimate Number	10281						
P.O. Number	:			Part Number	D3183043		
This Issue	02/05/2008 S.O. No. :			Drawing Number	D3183 REV C1		
Prsht Rev.	NC			Project Number	N/A		
First Issue	11 Type : MACHINED PARTS			Drawing Revision	C1		
Previous Run	37072			Material	:		
Written By	:			Due Date	30/05/2008		
Checked & Approved By	<u>JWD</u> 08-5-02			Qty:	24 Um: Each		
Comment	Est Rev: Pick:A 04.02.18 New issue KJ/DS						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M174B2000X01500	17-4 SS Bar	
		Comment: Qty.: 0.4812 f(s)/Unit Total : 11.5492 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.500x02.000) Identify for D3183-043 Batch: <u>M14773</u> x 26Lunks HA/SQ/bnd 08/05/21	3 x M17478 <u>M14773 x 26Lunks HA/SQ/bnd 08/05/21</u> 3 x M14773
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: (1.500" x 2.000") 5.500" long	<u>HA/SQ/bnd 08/05/21 (26Lunks)</u> (24)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3183-3 as per Folio FA322 and Dwg D3183 Identify as D3183-3 2-Deburr 3-Scribe batch number	<u>HA/SQ/bnd 08/05/21</u> (24)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>HA/SQ/bnd 08/05/21</u>

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Drawing Name: BRACKET ASSEMBLY

Job Number: 38982

Part Number: D3183043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



(22)

Comment: SECOND CHECK

08/05/30

6.0 D312121

Bolt



✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3121-21 Bolt 338994 x 16

339047 x 16 = D / H.A 08/05/29

7.0 D3183045

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 48.0000 Each(s)

B 38946 x 6

Pick:

Qty Part Number Description Batch

2 D3183-045 Bearing Ass

338983 x 6 = D / H.A

08/05/29

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3183-043 as per Dwg D3183.

S / b.a

08/05/29

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/29 (22)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Peggy/30

(22)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/30 (22)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CY08/05/30

DART AEROSPACE LTD	Work Order:	38982
Description: Bracket	Part Number:	D3183-3
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.188	/			
R0.063	+/-0.010	R.063	/			
0.182	+/-0.010	.185	/			
0.070	+/-0.010	0.073	/			
0.100	+/-0.010	.100	/			
Ø0.201 x 0.100	+/-0.010	Ø0.201 x 100	/			
0.182	+/-0.010	.185	/			
5.32	+/-0.030	5.323	/			
5.036	+/-0.010	5.036	/			
2.120	+/-0.010	2.120	/			
1.290	+/-0.010	1.290	/			
0.365	+/-0.010	.366	/			
0.218	+/-0.010	.211	/			
1.030	+/-0.010	1.030	/			
1.90	+/-0.030	1.887	/			
1.012	+/-0.010	1.012	/			
Ø0.201 x 0.100	+/-0.010	Ø0.201 x 100	/			
0.786	+/-0.010	0.778	/			
Ø0.392	+0.002/-0.000	Ø0.393	/			
R0.19	+/-0.030	R.19	/			
3.954	+/-0.010	3.954	/			
0.162	+/-0.010	0.160	/			
R0.19	+/-0.030	R.19	/			
R0.25	+/-0.030	R.25	/			
4.26	+/-0.030	4.26	/			
2.080	+/-0.030	2.070	/			
1.155	+/-0.010	1.150	/			
0.162	+/-0.010	0.162	/			
0.36	+/-0.030	0.355	/			
0.615	+/-0.010	.615	/			
0.435	+/-0.010	0.436	/			
0.200	+/-0.010	0.203	/			
0.381	+/-0.010	0.370	/			
0.032	+/-0.010	0.030	/			

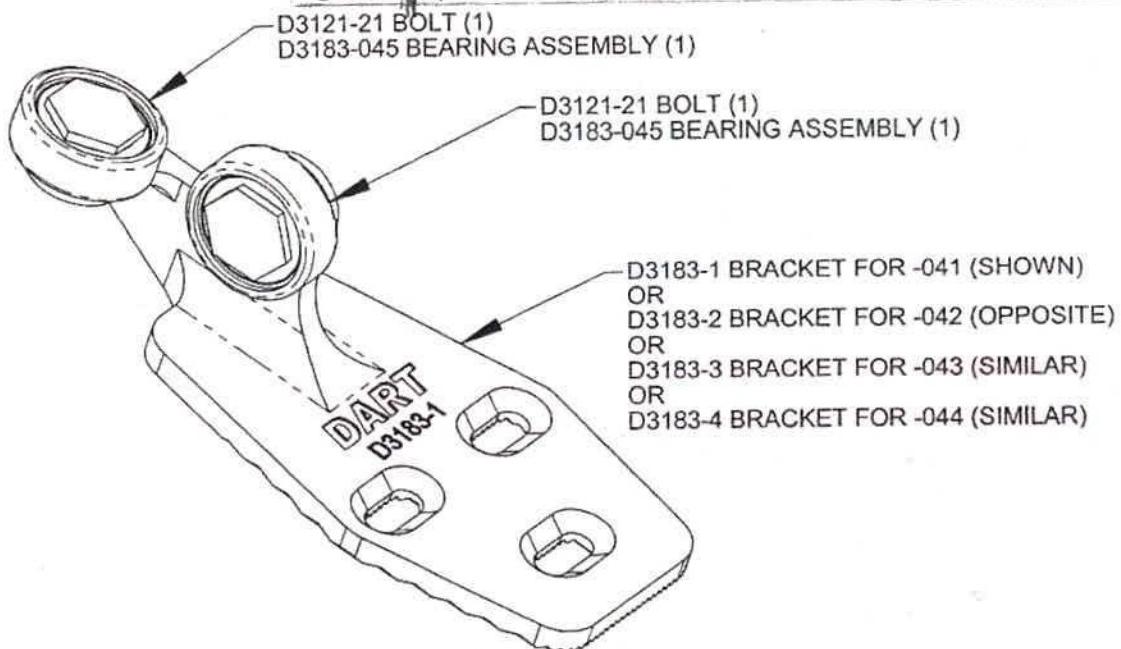
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/05/23	Date:	08/05/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
03.11.12	New Issue	P/O D3183-043	KJ/RF	
04.03.15	Changes as per revision C		KJ/JLM/RF	
06.03.09	Dwg Rev update		KJ/JLM	
01.01.28	0.182 dimension removed		KJEC/DD	

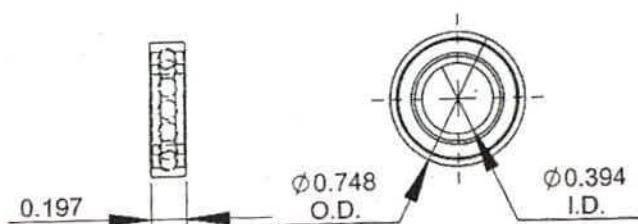
DART

OF COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

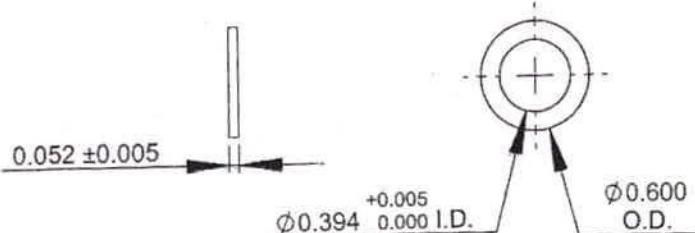


D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800Z
- 3) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER

No. 38982



D3183-7 WASHER

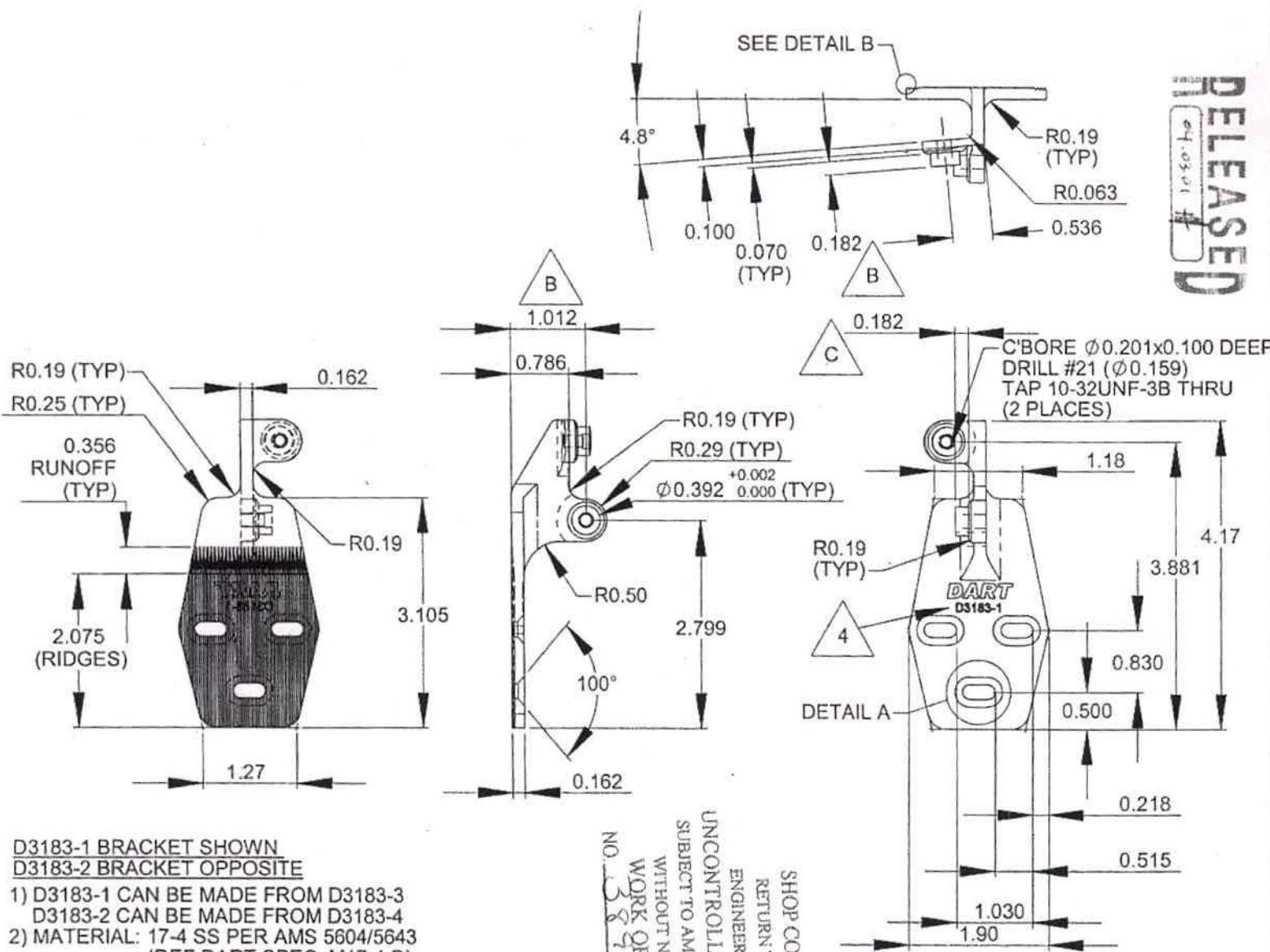
- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD
#	<i>(Signature)</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	<i>(Signature)</i>	D3183
DATE	TITLE	REV. C
04.02.17	BRACKET ASSEMBLY	SHEET 2 OF 4
		SCALE
		1:2



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSIT

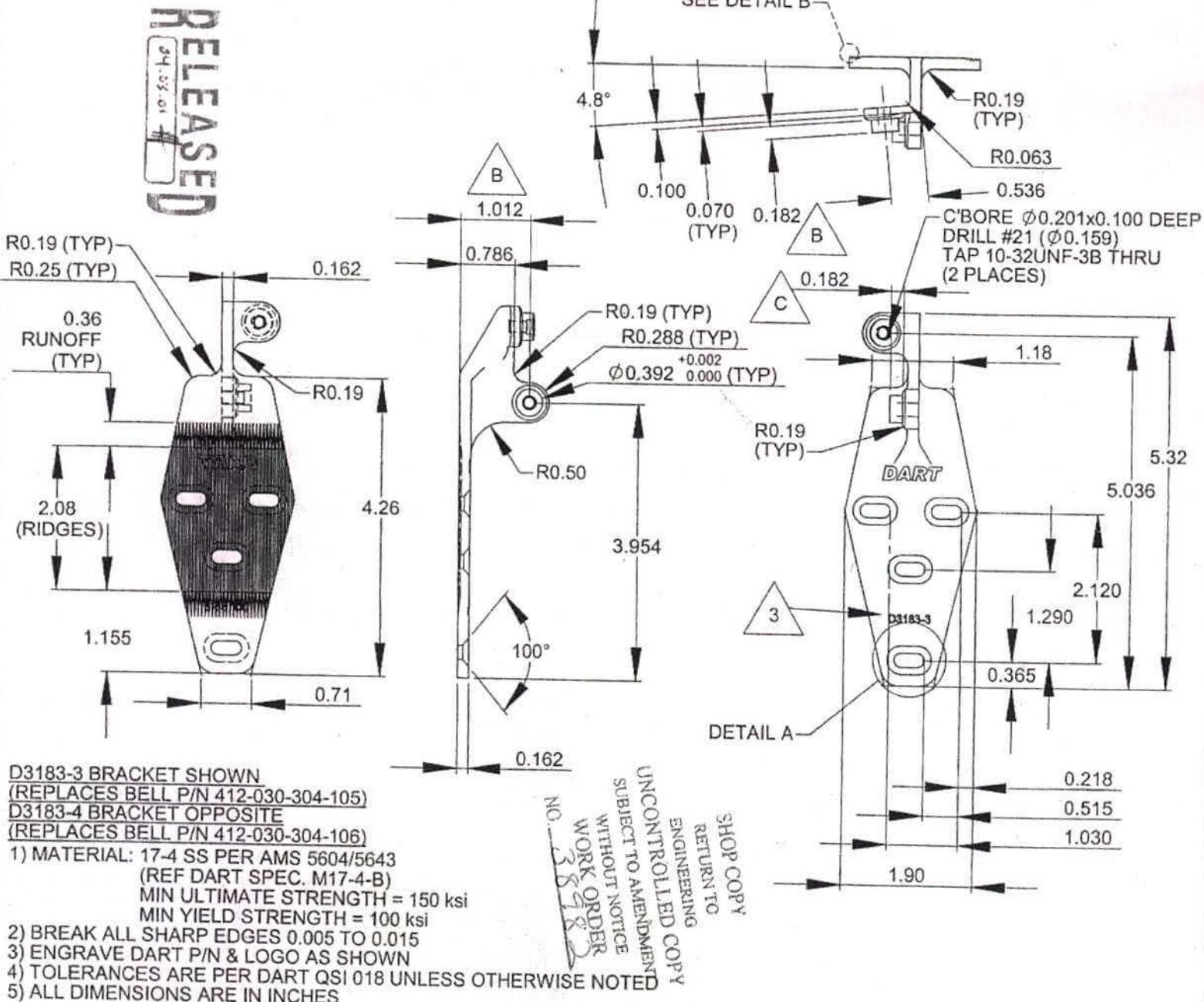
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
 - 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 4) ENGRAVE DART P/N & LOGO AS SHOWN
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES

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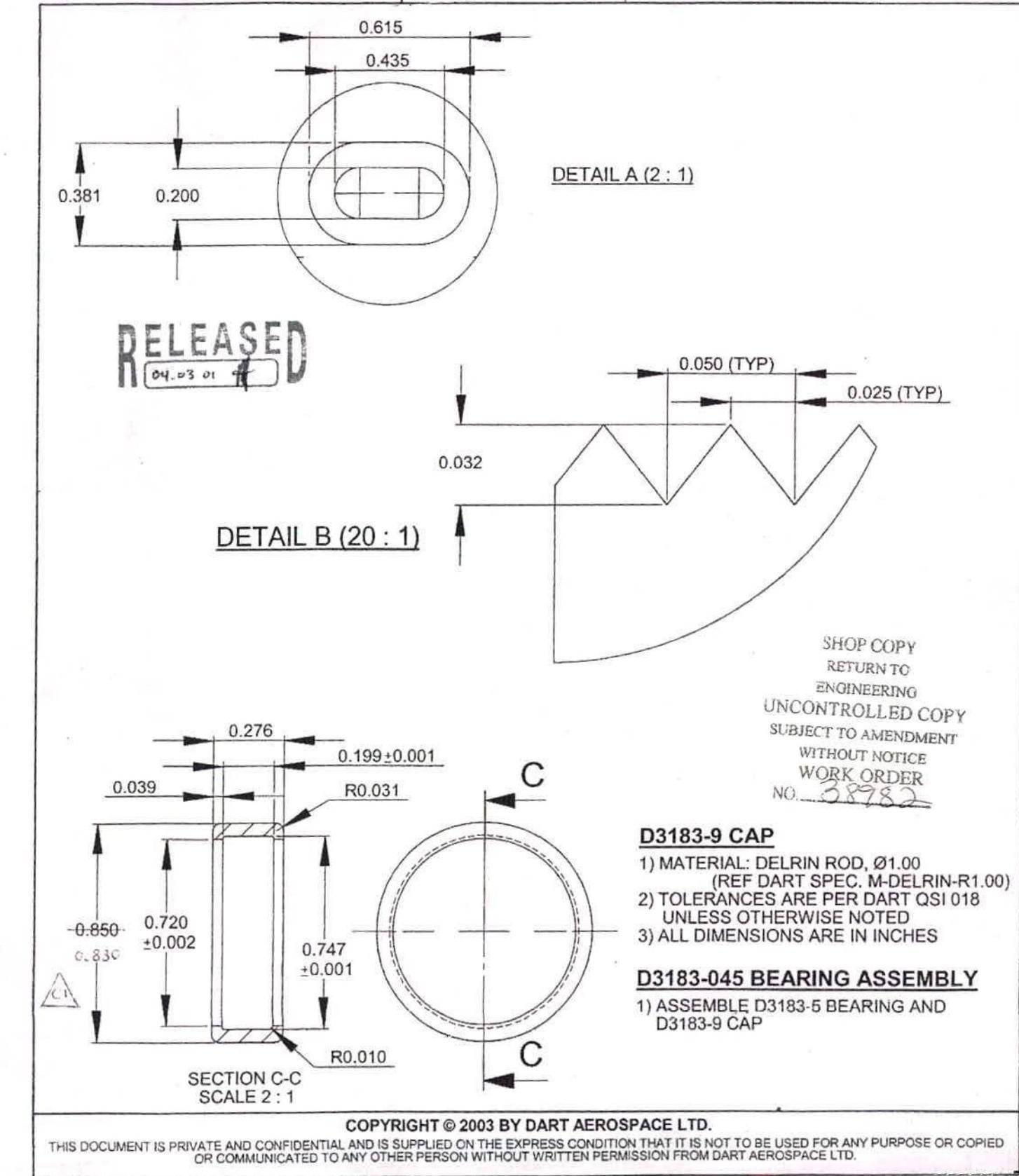


DESIGN #	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD
CHECKED	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	04.02.17	DRAWING NO. D3183
		SHEET 3 OF 4
		SCALE 1:2



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	TITLE	SCALE 1:1



WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

3183-043

Part No: ~~DXXXXXX~~ PAR #: _____ Fault Category: See Main WO NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/23	S.O	3 parts scrap 4 parts flew off the jig while machining. Reason: R.C material		Scrap and destroy and Replace Qty(12) B& m19478	SD 08/05/23	08/05/30		
08/05/23	S.O	1 part scrap. 7 pins off by .010" Reason: operator error	SD 08/05/23	Scrap and Destroy and Replace Qty(6) B& m19478	SD 08/05/23	08/05/30	08/05/30	08/05/30
08/05/25	S.O	2 parts scrap 3 parts flew off the jig while machining Reason: round copper mm		Scrap and Destroy and Replace B& m14773	MA 08/05/25	08/05/30		

NOTE: Date & initial all entries R.L material